

Work Order ID 162773

Monday, June 12, 2017 1:35:06 PM

647.3801
B162773
REV N/C

162773

Page 1

Item ID: 647.3801

Revision ID:

Item Name: 412 Upper Cutter Assembly

Start Date: 6/13/2017 Start Qty: 2.00

Required Date: 6/16/2017 Req'd Qty: 2.00

Reference:

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

3
3

Approvals: Process Plan: DAS Date: JUN 12 2017

Tooling:

Date:

Run Start *NR1*

QC: 9-89

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
647.3800	n/c

110 Pick Kit 0.00

110

Packaging

Memo

0.00

Packaging

3

JUN 14 2017

DAS
6
9-89

120 0.00

120

Small Fab

Memo

0.28

Small Fab

Assemble as per dwg and apply loctite 598 on all faying surfaces per note 2.

A/R RTV LOCTITE 598: 137328
exp. date: 04/19

3x

17/06/20

DAS
36
9-89

130 QC5- Inspect part completeness to step on W/O 0.00

130

QC

Memo

0.04

Quality Control

3

DAS
38
9-89
JUN 20 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Work Order ID 162773

Monday, June 12, 2017 1:35:06 PM

162773

Page 2

Item ID: 647.3801 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: 412 Upper Cutter Assembly
Start Date: 6/13/2017 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 6/16/2017 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Identify as per dwg & Stock Location: <u>CCT 028</u>	0.00				3	DAS 6		
140									
Packaging	Memo	0.02							
Packaging	***IDENTIFY AS PER IAW MPP-120***								JUN 21 2017
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.20							17/6/21 <i>[Signature]</i>
Quality Control									



JUN 21 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : _____		

Picklist Print

Monday, June 12, 2017 1:35:12 PM

Page 1

Work Order ID: 162773

162773

Parent Item: 647.3801

647.3801

Parent Item Name: 412 Upper Cutter Assembly

Start Date: 6/13/2017

Required Date: 6/16/2017

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 12.10.25 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
646.9701		Manufactured	No			110	Each	10.0000	1	23			DAS 6 9-8c
646.9701									**			JUN 14 2017	
Cutter Sub Assembly													

Location	Loc Qty	Loc Code
CCK007	10	
161785	3	2/1/2019
161786	3	2/1/2019
160771	4	2/12/2019

NAS1149FN832P		Purchased	No			110	Each	1,755.000	6	12/8			DAS 6 9-8c
NAS1149FN832P									**			JUN 14 2017	
Washer													

Location	Loc Qty	Loc Code
GA	358	
M135058	208	
M136182	40	
M136866	110	
ST263	1397	
M137412	1397	

MS21042L08		Purchased	No			110	Each	933.0000	3	29			DAS 6 9-8c
MS21042L08									**			JUN 14 2017	
Nut													

Location	Loc Qty	Loc Code
GA	100	
m135274	6	
m135978	94	
ST303	833	
m137391	359	
m137464	224	
m137736	250	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____	
Root Cause		FAULT CATEGORY							
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong				
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions				
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance				
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect				
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing				
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved				
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing				
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish				
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread				
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence				
Past Expiry Date ☐	☐ Manufacturing Process	OTHER : _____							
Misidentified ☐	☐ Past Due								

Picklist Print

Monday, June 12, 2017 1:35:12 PM

Page 2

Work Order ID: 162773

162773

Parent Item: 647.3801

647 3801

Parent Item Name: 412 Upper Cutter Assembly

Start Date: 6/13/2017

Required Date: 6/16/2017

Start Qty: 2.00

Required Qty: 2.00

MS27039-08-19

Purchased

No

110

Each

284.0000

3

~~69~~

MS27039-08-19

**

Screw

JUN 14 2017

DAS

6

9-89

Location

Loc Qty

Loc Code

GA

30

m135948

26

m137178

4

ST277

254

m137361

54

m137464

200

4
5

647.3910

Manufactured

No

110

Each

5.0000

1

2

647 3910

**

412 Upper Deflector

JUN 14 2017

DA

6

9-8

Location

Loc Qty

Loc Code

cck082

5

124426

1

144768

4

1
2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

NOTES:

1. IDENTIFY IAW MPP-120
2. APPLY F/N 9 AS REQUIRED TO ALL FAYING SURFACES OF F/N 1, 5, 6, 7, & 8 UPON ASSEMBLY

REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
	LAST PROTOTYPE REVISION: PP1		N/C
N/C	INITIAL RELEASE	07/08/09	F. GUNAWAN

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

WORK ORDER
NO. 162773 MJS
1706-12

			I	9	647.3911	212 UPPER DEFLECTOR		
			I	8	647.3910	412 UPPER DEFLECTOR		
A/R	A/R	A/R	A/R	7	601.2045	RTV. LOCITE 598		
I				6	647.3902	LOWER DEFLECTOR ASSY HIGH		
.I				5	647.3901	LOWER DEFLECTOR ASSY LOW		
S	S	S	S	4	601.2765	SCREW	M527029P-0819	
S	S	S	S	3	601.1541	LOCKNUT	M521043708	
6	6	6	6	2	601.2764	WASHER	M4S1147F1B32P	
I	I	I	I	1	646.9701	CUTTER SUB ASSY		
X	X	X	X		647.3804	LOWER CUTTER ASSY HIGH		
X	X	X	X		647.3803	LOWER CUTTER ASSY LOW		
X	X	X	X		647.3802	212 UPPER CUTTER ASSY		
X	X	X	X		647.3801	412 UPPER CUTTER ASSY		
3804	3803	3802	3801	FIND #	PART #	DESCRIPTION	MAT'L	SPEC
QTY						PART LIST		
NEXT ASSY (S)						APICAL INDUSTRIES		
647.3700						2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-53		
						CUTTER ASSY		
						REV	CAGE CODE	DWG. NO.
						B	07M16	647.3800
						SCALE NONE		SHEET
								OF

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																							
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Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																																																												
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OTHER : _____																																																															